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DART AEROSPACE LTD	Work Order:	188617
Description: Bracket Assembly	Part Number:	D3152-041
		D3152-042
Drawing: D3152 Rev.A D3152-1/-2 replaces Premier P/N: B30-23000-223/-224 D3152-3/-4 replaces Premier P/N: B30-23000-243/-244	Qty:	12 Kits Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Note: D3152-041/-042 Kits to be made in multiples of 12. Each Kit consists of Qty (1) of -041 and Qty (1) of -042.	HJ	03.02.26	12
2	PG	Note: Each D3152 Kit ordered from Delastek consists of Qty (12) D3152-3 and Qty (12) D3152-4, therefore, for each multiple of 12 x D3152-041/-042 Kit, order Qty 1 x D3152 Seal Kit. Issue P/O: 2005210 D3152-3/-4 Seal as per Dwg D3152 Supplier: Delastek Material: Black RTV Material release note required			
3	RG	Receive and inspect for transit damage. Identify as D3152-3 and D3152-4 as per Dwg D3152. Ensure the material release note is attached	LL	03.02.26	12
4	QC6	Inspect dimensions per Dwg D3152	BB	03.05.14	12
5	MV	Note: Flat pattern makes either D3152-1 or D3152-2 therefore cut (2) blanks for each kit. Cut blanks: (4.120" x 1.330") (+0.015/-0.00) grain along 4.120" Material: 2024-T3 (QQ-A-250/4) 0.063" thick. (M2024T3S.063)	M11225 Batch: M11094	ML 03/03/17	24
6	MV	Machine as per Folio FA311 and Dwg D3152 Use stack of 4	ML	03/03/18	1224
7	QC2	Inspect parts as they come off the CNC machine	ML	03/03/18	1224
8	MV	Deburr	ML	03/03/18	1224
9	QC8	Second check	SL	03/03/19	1224
10	GB	Form half of total stack as D3152-1 per Dwg D3152. Identify as D3152-1	ML	03/04/23	1224
11	GB	Form other half of stack as D3152-2 per Dwg D3152. Identify as D3152-2	ML	03/04/23	1224
12	QC5	Inspect work to Step 11	BB	03.04.23	24
13	FP	Chemical Conversion Coat per QSI 005 4.1	AA	03.04.23	24
14	FP	Powder Coat Grey Sandtex (4.3.5.6) per QSI 005 4.3	MM	03.05.08	24
15	QC3	Inspect Powder Coat	BB	03.05.08	24
16	GA	Bond D3152-3 Seal to D3152-1 Bracket using RTV 732 per Dwg D3152. RTV 732 Black Batch: M13088 Expiry: July 104	BB	03.05.20	12

RELEASED
03.02.26 RT

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